

Date: Thursday, 6/29/2006 10:13:01 AM  
 User: Chantal Lavoie

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642-312
Job Number : 27779	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 6/29/2006 S.O. No. : N/A	Drawing Number : CHG 004
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : N/A	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : <u>                    </u>	Due Date : 7/6/2006 Qty: 2 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : <u>                    </u>	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
 REMOVE FROM STOCK  
 D206-642-312 B21057  
 D206-642-312 B21058

FC

2.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
 REMOVE D2648-3 WEARPLATES  
 D2648-3 B 21088 — add to Accpac adj 11617  
 AND REPLACE WITH D3429-1 WEARPLATES  
 D3429-1 B 24417  
 TO MAKE CHG 004

FC

3.0	D34291
-----	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

FC 06 06 29 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

WJ 06 06 29

(2)

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-312

Job Number: 27779

Part Number: Z\_CUSTOM

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REPACKAGE PER PPP  
WITH SAME B/N...CHG 004

FC 06 06 29 (2)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

add copy to each Batch

Job Completion



Inspection Level 21 2706/06/09 (2)

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	21058
<b>Description:</b> 206 L/L1/L3/L4/407 Low Gear Skidtube 407 High Gear Skidtube	<b>Part Number:</b>	D206-642-341
<b>Drawing:</b> D2650 Rev. C1 Pages 1,4,6 & 7; DEO 9136 Rev. A; DEO 9153 Rev. A, DEO 9163 Rev. A	<b>Qty:</b>	1
		Page 2 of 3

Step	Location	Procedure	By	Date	Qty																																				
19	LG	Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>17</td><td>D2649</td><td>Crossbolt spacer</td><td>B21689</td></tr><tr><td>A/R</td><td></td><td>Aluminum Rod</td><td>M13252</td></tr></table>	Qty	Part Number	Description	Batch	17	D2649	Crossbolt spacer	B21689	A/R		Aluminum Rod	M13252	DP	04/08/30	1																								
Qty	Part Number	Description	Batch																																						
17	D2649	Crossbolt spacer	B21689																																						
A/R		Aluminum Rod	M13252																																						
20	LG	Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube	DP	04/08/30	1																																				
21	LG	Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr	DP	04/08/30	1																																				
22	FP	Install D2680-041 Nut Plate as per Dwg D2650 <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>CCR264SS3-3</td><td>Rivets</td><td>M15191</td></tr><tr><td>2</td><td>M7885/3-4-3</td><td>Rivets</td><td>B11822</td></tr><tr><td>1</td><td>D2680-041</td><td>Nut Plate</td><td>B19753</td></tr></table>	Qty	Part Number	Description	Batch	2	CCR264SS3-3	Rivets	M15191	2	M7885/3-4-3	Rivets	B11822	1	D2680-041	Nut Plate	B19753	DP	04/09/8	1																				
Qty	Part Number	Description	Batch																																						
2	CCR264SS3-3	Rivets	M15191																																						
2	M7885/3-4-3	Rivets	B11822																																						
1	D2680-041	Nut Plate	B19753																																						
23	QC5 & 9	Inspect weld and Counterbore work to Step 22 Inspect for foreign object per QSI 024	DP	04-09-16	1																																				
24	LG	Give Traveller D206-642-311 to PK	DP	04-09-16	1																																				
25	FP	Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3 <b>Make sure Nut Plate Thread protected use paint screw</b>	DP	04-09-21	1																																				
26	QC3	Inspect Powder Coat	DP	04-09-22	1																																				
27	FP	Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>7</td><td>D2648-3</td><td>Wearpad</td><td>B21088</td></tr><tr><td>1</td><td>D2656-11</td><td>Wearshoe</td><td>B21095</td></tr><tr><td>1</td><td>D2656-23</td><td>Wearshoe</td><td>B21096</td></tr><tr><td>1</td><td>D2656-35</td><td>Wearshoe</td><td>B20916</td></tr><tr><td>54</td><td>MS27039-1-08</td><td>Screw</td><td>M14312</td></tr><tr><td>54</td><td>ALS4-1032-130</td><td>Inserts</td><td>M14240</td></tr><tr><td>54</td><td>AN960JD10L</td><td>Washer</td><td>M15191</td></tr><tr><td>A/R</td><td></td><td>Sikaflex-291</td><td>M15147</td></tr></table> <b>Sikaflex expire date:</b> 04/12/02	Qty	Part Number	Description	Batch	7	D2648-3	Wearpad	B21088	1	D2656-11	Wearshoe	B21095	1	D2656-23	Wearshoe	B21096	1	D2656-35	Wearshoe	B20916	54	MS27039-1-08	Screw	M14312	54	ALS4-1032-130	Inserts	M14240	54	AN960JD10L	Washer	M15191	A/R		Sikaflex-291	M15147	DP	04-09-22	1
Qty	Part Number	Description	Batch																																						
7	D2648-3	Wearpad	B21088																																						
1	D2656-11	Wearshoe	B21095																																						
1	D2656-23	Wearshoe	B21096																																						
1	D2656-35	Wearshoe	B20916																																						
54	MS27039-1-08	Screw	M14312																																						
54	ALS4-1032-130	Inserts	M14240																																						
54	AN960JD10L	Washer	M15191																																						
A/R		Sikaflex-291	M15147																																						
28	FP	Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>14</td><td>D2651-1</td><td>Plugs</td><td>B20528</td></tr><tr><td>14</td><td>D2651-3</td><td>O-Rings</td><td>B20110</td></tr></table>	Qty	Part Number	Description	Batch	14	D2651-1	Plugs	B20528	14	D2651-3	O-Rings	B20110	DP	04-09-22	1																								
Qty	Part Number	Description	Batch																																						
14	D2651-1	Plugs	B20528																																						
14	D2651-3	O-Rings	B20110																																						
29	FP	Install MS27039-4-06 Screw as per DEO 9153 <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>MS27039-4-06</td><td>Screw</td><td>M6874</td></tr><tr><td>1</td><td>AN960JD416</td><td>Washer</td><td>M11151</td></tr></table>	Qty	Part Number	Description	Batch	1	MS27039-4-06	Screw	M6874	1	AN960JD416	Washer	M11151	DP	04-09-22	1																								
Qty	Part Number	Description	Batch																																						
1	MS27039-4-06	Screw	M6874																																						
1	AN960JD416	Washer	M11151																																						

REFERENCE ONLY

RELEASED  
02/05/10 JF

<b>ART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>21057</b>
<b>Description:</b> 206 L/L1/L3/L4/407 Low Gear Skidtube	<b>Part Number:</b>	<b>D206-642-341</b>
407 High Gear Skidtube		
<b>Drawing:</b> D2650 Rev. C1 Pages 1,4,6 & 7; DEO 9136 Rev. A; DEO 9153 Rev. A, DEO 9163 Rev. A	<b>Qty:</b>	<b>1</b>
		<b>Page 2 of 3</b>

Step	Location	Procedure	By	Date	Qty																																					
19	LG	Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>17</td><td>D2649</td><td>Crossbolt spacer</td><td>B21089</td></tr><tr><td>A/R</td><td></td><td>Aluminum Rod</td><td>M13252</td></tr></table>	Qty	Part Number	Description	Batch	17	D2649	Crossbolt spacer	B21089	A/R		Aluminum Rod	M13252	AS	04/08/30	1																									
Qty	Part Number	Description	Batch																																							
17	D2649	Crossbolt spacer	B21089																																							
A/R		Aluminum Rod	M13252																																							
20	LG	Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube	DP	04/08/30	1																																					
21	LG	Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr	DP	04/08/30	1																																					
22	FP	Install D2680-041 Nut Plate as per Dwg D2650 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>CCR264SS3-3</td><td>Rivets</td><td>M15191</td></tr><tr><td>2</td><td>M7885/3-4-3</td><td>Rivets</td><td>B11822</td></tr><tr><td>1</td><td>D2680-041</td><td>Nut Plate</td><td>B19253</td></tr></table>	Qty	Part Number	Description	Batch	2	CCR264SS3-3	Rivets	M15191	2	M7885/3-4-3	Rivets	B11822	1	D2680-041	Nut Plate	B19253	DP	04/09/8	1																					
Qty	Part Number	Description	Batch																																							
2	CCR264SS3-3	Rivets	M15191																																							
2	M7885/3-4-3	Rivets	B11822																																							
1	D2680-041	Nut Plate	B19253																																							
23	QC5 & 9	Inspect weld and Counterbore work to Step 22 Inspect for foreign object per QSI 024	AS	04.09.16/1																																						
24	LG	Give Traveller D206-642-311 to PK	MM	04.09.16	1																																					
25	FP	Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3 <b>Make sure Nut Plate Thread protected use paint screw</b>	Z	04.09.21	1																																					
26	QC3	Inspect Powder Coat	MM	04.09.22	1																																					
27	FP	Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>7</td><td>D2648-3</td><td>Wearpad</td><td>B21088</td></tr><tr><td>1</td><td>D2656-11</td><td>Wearshoe</td><td>B21095</td></tr><tr><td>1</td><td>D2656-23</td><td>Wearshoe</td><td>B21056</td></tr><tr><td>1</td><td>D2656-35</td><td>Wearshoe</td><td>B20916</td></tr><tr><td>54</td><td>MS27039-1-08</td><td>Screw</td><td>M14312</td></tr><tr><td>54</td><td>ALS4-1032-130</td><td>Inserts</td><td>M14246</td></tr><tr><td>54</td><td>AN960JD10L</td><td>Washer</td><td>M15151</td></tr><tr><td>A/R</td><td></td><td>Sikaflex-291</td><td>M15147</td></tr></table> <b>Sikaflex expire date:</b> 04/12/02	Qty	Part Number	Description	Batch	7	D2648-3	Wearpad	B21088	1	D2656-11	Wearshoe	B21095	1	D2656-23	Wearshoe	B21056	1	D2656-35	Wearshoe	B20916	54	MS27039-1-08	Screw	M14312	54	ALS4-1032-130	Inserts	M14246	54	AN960JD10L	Washer	M15151	A/R		Sikaflex-291	M15147	REFERENCE ONLY Z		04-09-22	1
Qty	Part Number	Description	Batch																																							
7	D2648-3	Wearpad	B21088																																							
1	D2656-11	Wearshoe	B21095																																							
1	D2656-23	Wearshoe	B21056																																							
1	D2656-35	Wearshoe	B20916																																							
54	MS27039-1-08	Screw	M14312																																							
54	ALS4-1032-130	Inserts	M14246																																							
54	AN960JD10L	Washer	M15151																																							
A/R		Sikaflex-291	M15147																																							
28	FP	Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>14</td><td>D2651-1</td><td>Plugs</td><td>B20528</td></tr><tr><td>14</td><td>D2651-3</td><td>O-Rings</td><td>B20116</td></tr></table>	Qty	Part Number	Description	Batch	14	D2651-1	Plugs	B20528	14	D2651-3	O-Rings	B20116	Z	04.09.22	1																									
Qty	Part Number	Description	Batch																																							
14	D2651-1	Plugs	B20528																																							
14	D2651-3	O-Rings	B20116																																							
29	FP	Install MS27039-4-06 Screw as per DEO 9153 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>MS27039-4-06</td><td>Screw</td><td>M6674</td></tr><tr><td>1</td><td>AN960JD416</td><td>Washer</td><td>M11151</td></tr></table>	Qty	Part Number	Description	Batch	1	MS27039-4-06	Screw	M6674	1	AN960JD416	Washer	M11151	Z	04-09-22	1																									
Qty	Part Number	Description	Batch																																							
1	MS27039-4-06	Screw	M6674																																							
1	AN960JD416	Washer	M11151																																							

RELEASED  
04/09/10 Ref